

Work Order ID 74061

Wednesday, September 21, 2011 9:59:25 AM



Page 1

Item ID: D3784-044	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Seat Support Assembly, RH					
Start Date: 9/22/2011	Start Qty: 2.00		Cust Item ID:		
Required Date: 10/7/2011	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>MF</u>	Date: <u>11-09-21</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3784	Rev B								

100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

SP 11-10-12

110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-assemble as per dwg D3784□****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented down****□****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented forward****								

SP 11/10/12 (2)

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

SP 11/10/12

(2)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3784-044

Accept

Setup Start

Revision ID:

Stop

Item Name: Seat Support Assembly, RH

Start Date: 9/22/2011 Start Qty: 2.00

Required Date: 10/7/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*EP 11/10/19 (2)**11/10/19**ME**11-10-19*

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 21, 2011 9:59:22 AM

Page 1

Work Order ID: 74061

Parent Item: D3784-044

Parent Item Name: Seat Support Assembly, RH


Start Date: 9/22/2011

Required Date: 10/7/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN525-10R20 		Purchased	No			110	Each	81.0000	4	8			

Screw

Location

Loc Qty

Loc Code

ST325

81

113524

0

114348

31

114354

50

AN960JD10L NAS1149D0332J Purchased No



Washer

D3763-041



Manufactured No

End Fitting Assembly

D3763-044



Manufactured No

End Fitting Assembly, RH

Location

Loc Qty

Loc Code

ST243

1

60457

1

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W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 74061

Parent Item: D3784-044

Parent Item Name: Seat Support Assembly, RH

Start Date: 9/22/2011

Required Date: 10/7/2011

Start Qty: 2.00

Required Qty: 2.00

D3770-1

Manufactured No

110

Each

20.0000

1



Tube

Location

Loc Qty

Loc Code

ST248

2

56569

2

ST250

18

65060

8

67360

10

D3770-3

Manufactured No

110

Each

10.0000

1



Tube

Location

Loc Qty

Loc Code

ST250

8

65061

8

ST254

2

54318

2

MS21042L3

Purchased No

110

Each

2,592.000

4



Nut

Location

Loc Qty

Loc Code

ST300

2592

117441

24

117601

363

117885

205

118451

1000

118927

1000

Wednesday, September 21, 2011 9:59:23 AM

Shop Packet Print

Page 2

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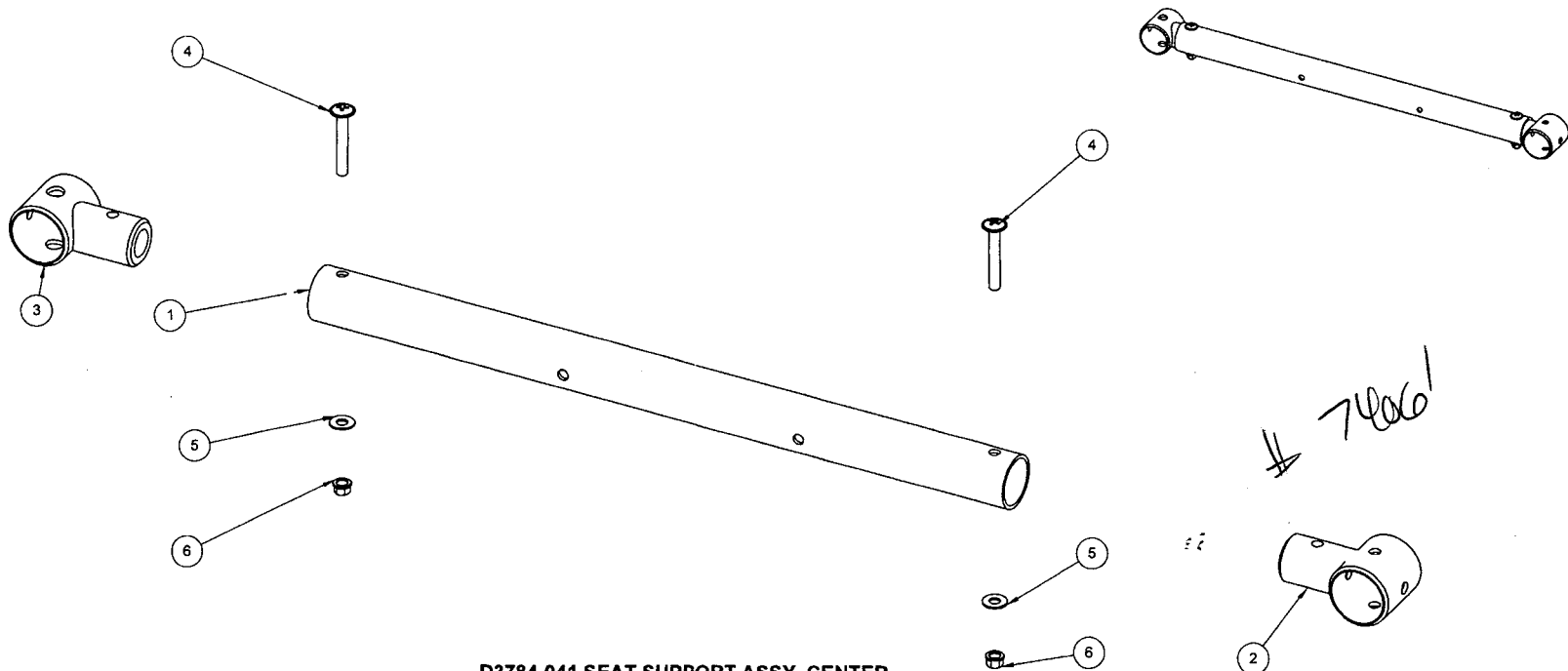
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NOTE: Date & initial all entries



D3784-041 SEAT SUPPORT ASSY. CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

B
 B
 B
 B

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.31 lbs

B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS	DRAWING NO.	REV. B
CHECKED	HS	D3784	SHEET 1 OF 5
MFG. APPR.	HS	TITLE	SCALE
APPROVED	HS	SEAT SUPPORT ASSEMBLY	NTS
DE APPR.	HS	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.06.23		

74061

RELEASED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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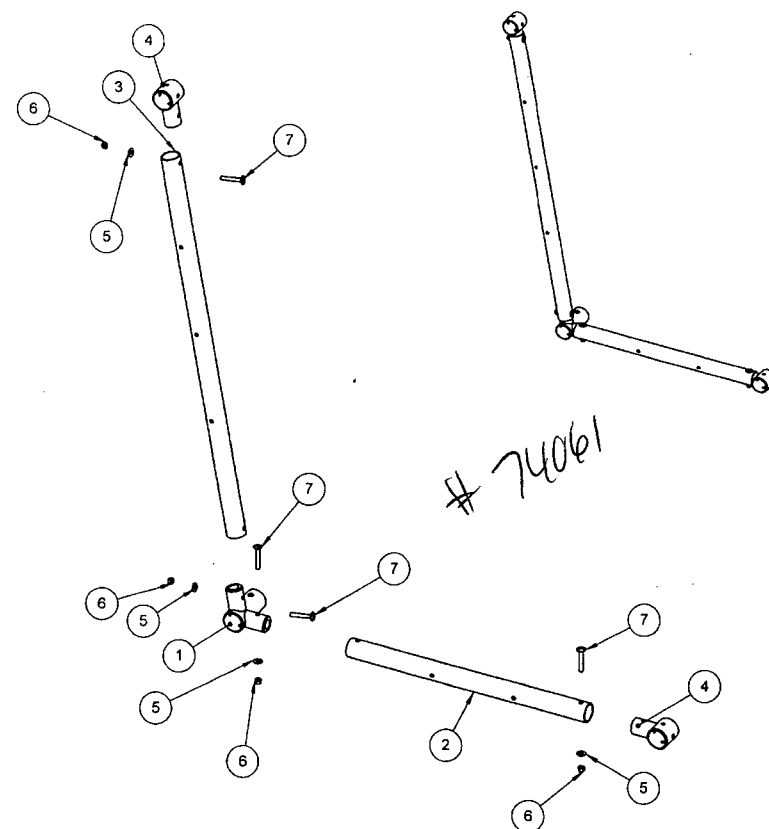
NOTE: Date & initial all entries

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

D3784-043 SEAT SUPPORT ASSY, LH

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.		D3784	SHEET 2 OF 5
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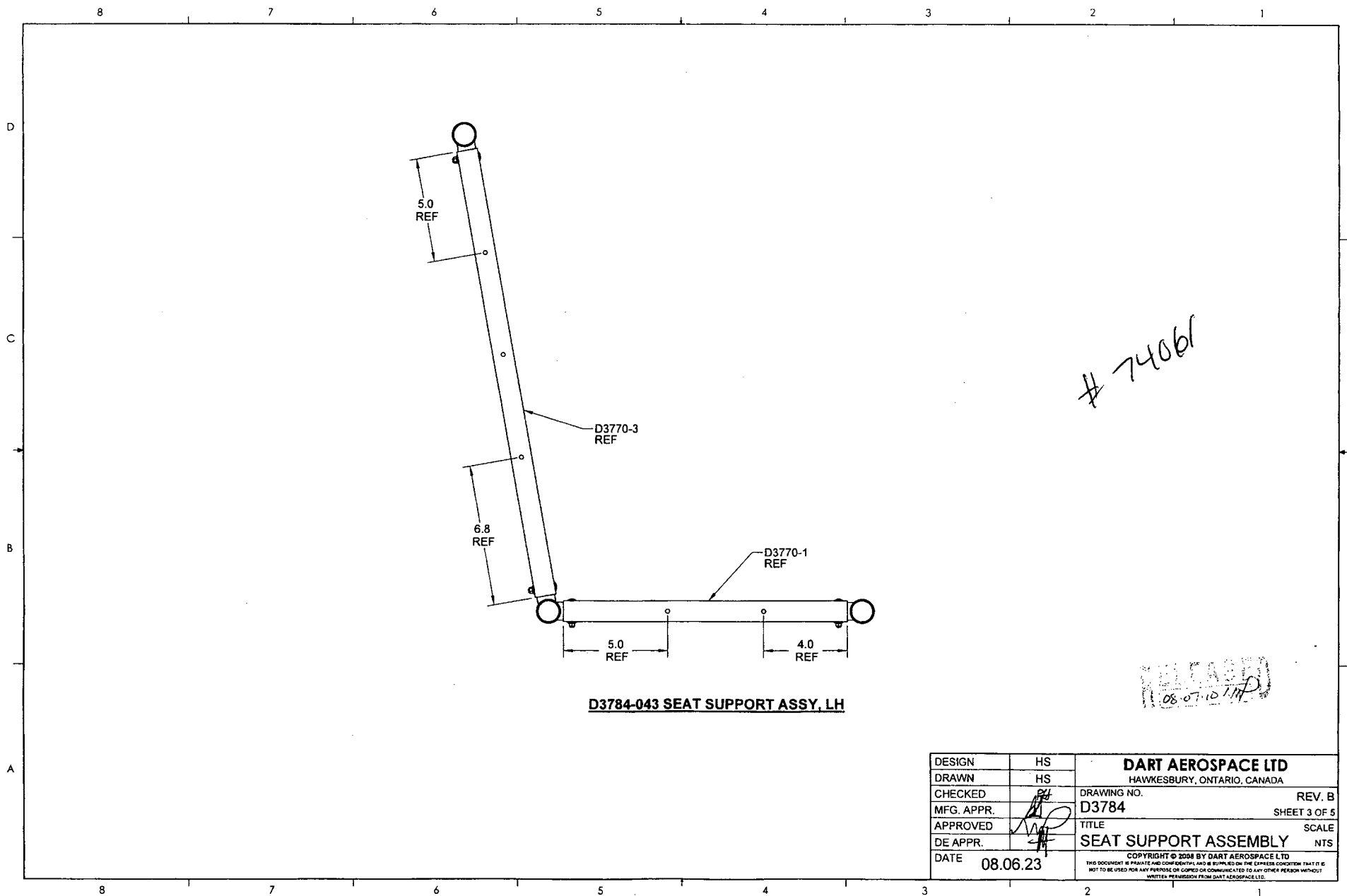
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MFG. APPR.		D3784	SHEET 3 OF 5
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8 7 6 5 4 3 2 1

D

C

B

A

D

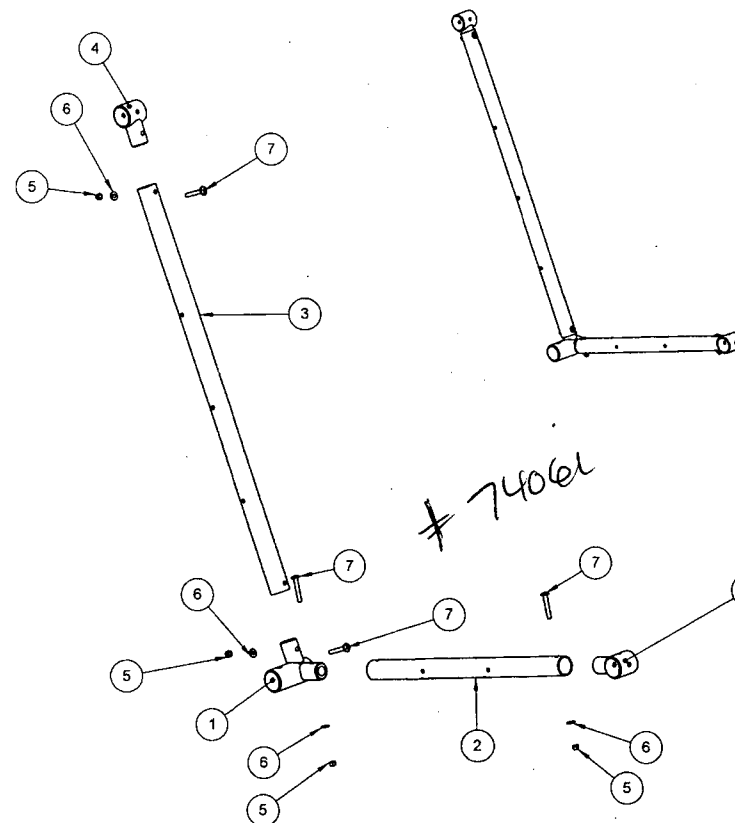
C

B

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

△B
△B
△B



D3784-044 SEAT SUPPORT ASSY, RH

RELEASED
08.06.23

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.78 lbs

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CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 4 OF 5
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8 7 6 5 4 3 2 1

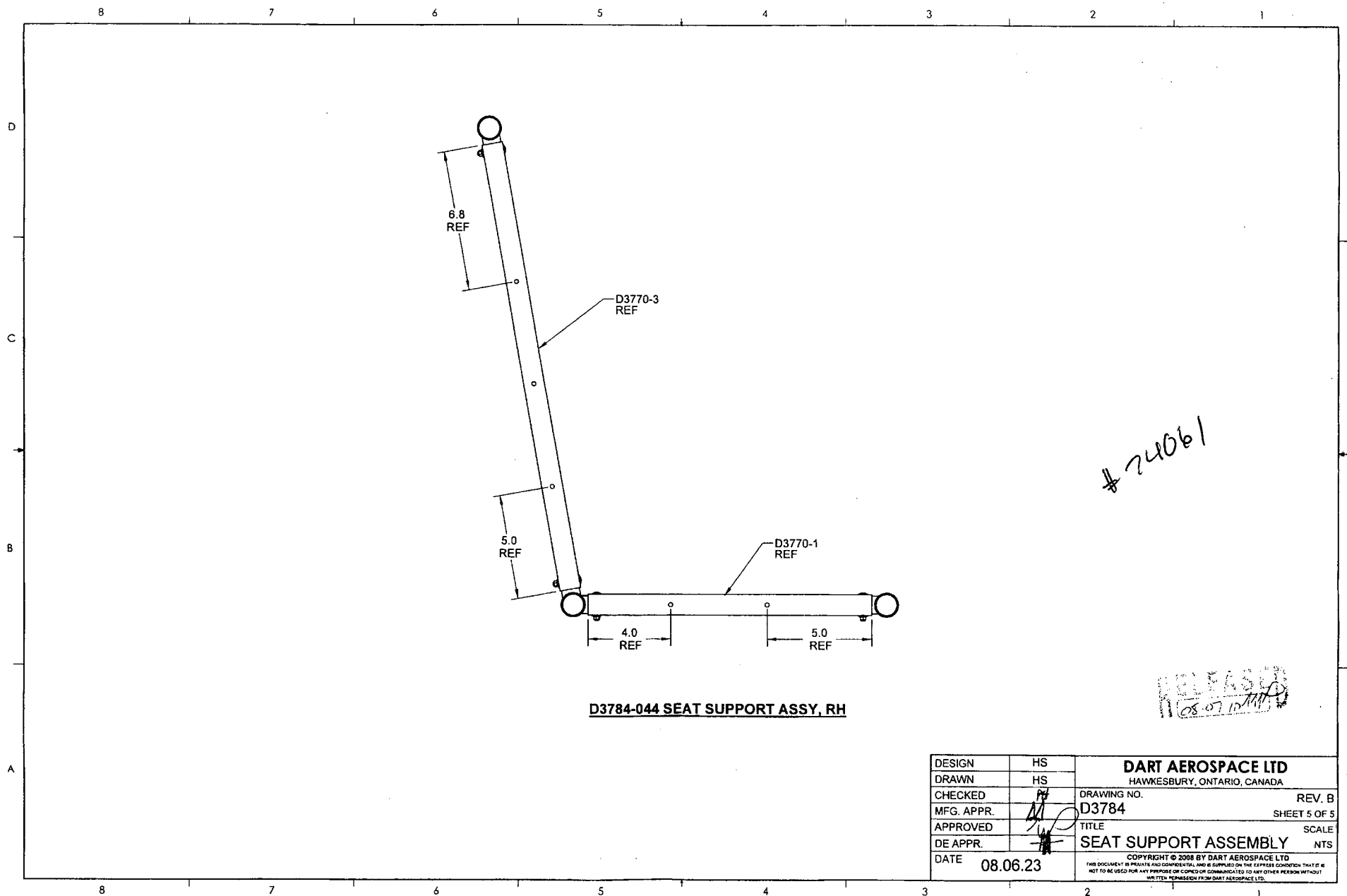
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